

# Work Order ID 81173

**\*81173\***

Page 1

March-12-12 8:37:48 AM

Item ID: D4034-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Upper Rib Assembly  
 Start Date: 09/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 19/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: ML5 Date: 12/03/12 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4034	B

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00

**\*100\***  
 Large Fab Memo 0.00  
 Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564  
 2- Weld bushing in rib as per dwg

*Handwritten: 12.04.09 (6)*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***  
 QC Memo 0.00  
 Quality Control

*Handwritten: 12.04.10 (6) 6*

120 QC5- Inspect part completeness to step on W/O 0.00

**\*120\***  
 QC Memo 0.00  
 Quality Control

*Handwritten: 12/04/10 (46) 6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*81173\***

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March-12-12 8:37:48 AM

Item ID: D4034-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Upper Rib Assembly

Stop **\*NS2\***

Start Date: 09/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: B.C.

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

*AD 12.04.10 (6)*

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*12/4/10*

*12-04-10*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

March-12-12 8:37:51 AM

Page 1

Work Order ID: 81173

\*81173\*

Parent Item: D4034-043

\*D4034-043\*

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
PER DWG REV.B DD VERF:EC  
IPP Rev:B as  
IPP Rev:C 11.01.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1		Manufactured	No			100	Each	8.0000	1	1			

\*D4034-1\*

Rib

\*\*

SAD 12-04-09

## Location

## Loc Qty

## Loc Code

WA006

8

78262

8

B81467

6

D4034-5

Manufactured No

100

Each

11.0000

1

1

\*D4034-5\*

Rib

\*\*

SAD 12-04-05

## Location

## Loc Qty

## Loc Code

WA

2

75656

2

WA005

8

67339

1

79418

7

WA006

1

70343

1

B82383

6

D2327-3

Manufactured No

100

Each

27.0000

1

1

\*D2327-3\*

Spacer Bushing

\*\*

SAD 12-04-05

## Location

## Loc Qty

## Loc Code

WA

25

79333

25

WA005

2

75564

1

77229

1

B81144

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-12-12 8:37:51 AM

Page 2

Work Order ID: 81173

**\*81173\***

Parent Item: D4034-043

**\*D4034-043\***

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-7

Manufactured No

100

Each

10.0000

1

1

**\*D4021-7\***

\*\*

Hoop

SAD 12-04-05

Location

Loc Qty

Loc Code

WA005

10

79877

10

381184

381446

2

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

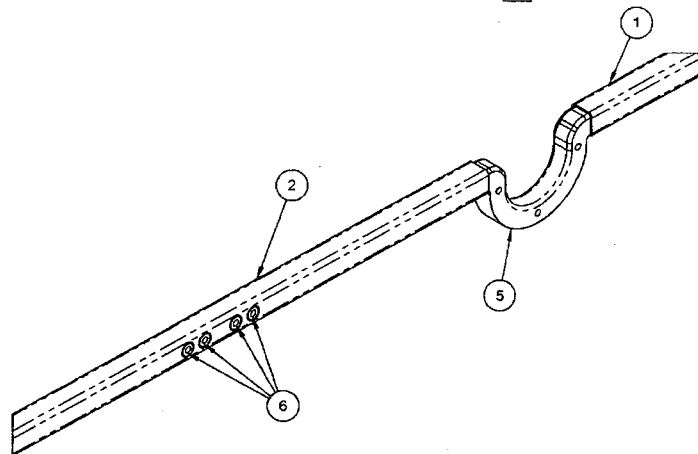
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

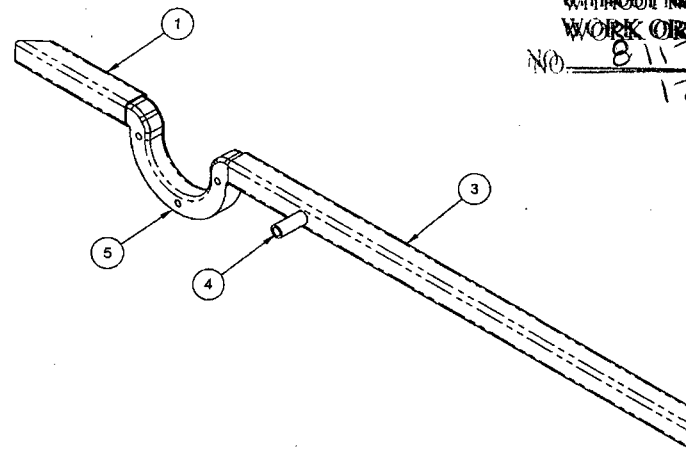
**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



**D4034-041 AFT UPPER RIB ASSY**



**D4034-043 FWD UPPER RIB ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 81173 MCT  
12/03/12

RELEASED  
2011-01-18  
M

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	R	DRAWING NO.	REV. B
MFG. APPR.	M	D4034	SHEET 1 OF 4
APPROVED	M	TITLE	SCALE
DE APPR.	M	UPPER RIB ASSY, BASKET BASE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

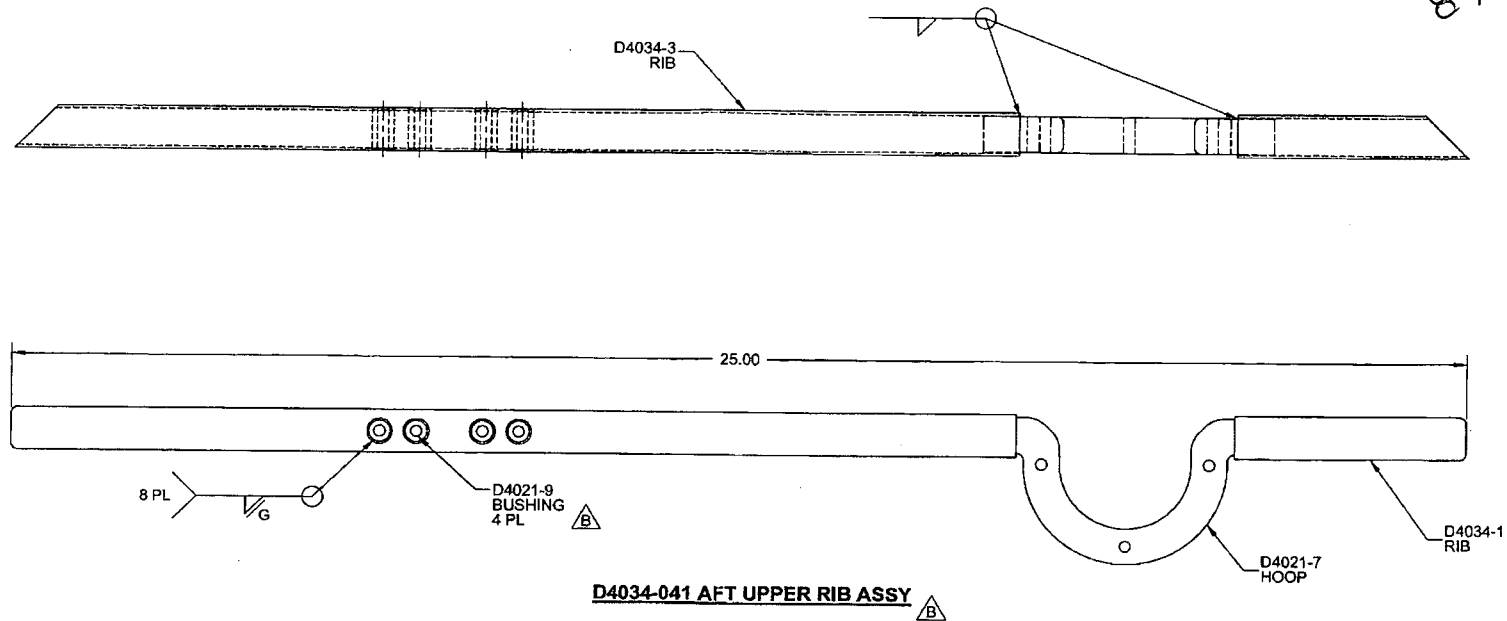
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81173



**D4034-041 AFT UPPER RIB ASSY**

RELEASED  
2011-01-18

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	<b>D4034</b>	SHEET 2 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	<b>UPPER RIB ASSY, BASKET BASE</b>	NTS
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W/O:		WORK ORDER CHANGES					
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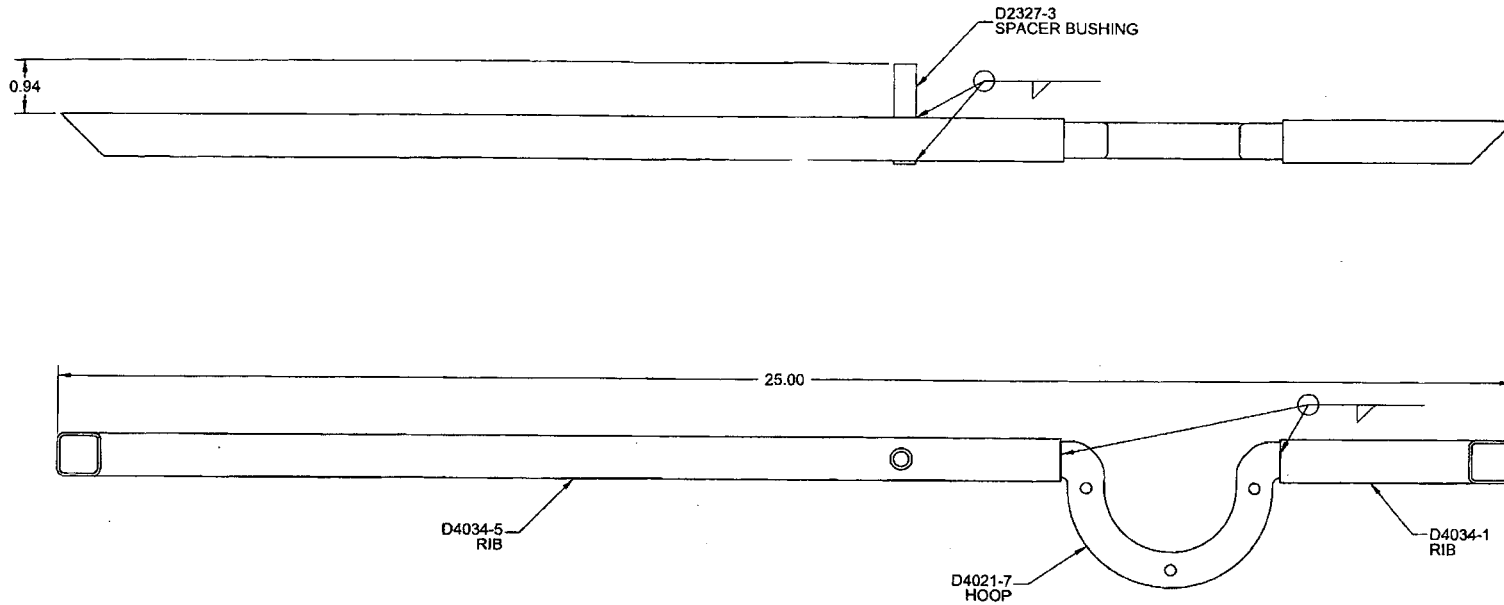
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81173



**D4034-043 FWD UPPER RIB ASSY**

**RELEASED**  
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.58 lbs
  - 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	<b>D4034</b>	SHEET 3 OF 4
APPROVED	[Signature]	TITLE	SCALE
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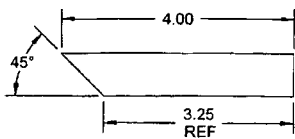
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

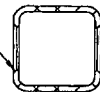
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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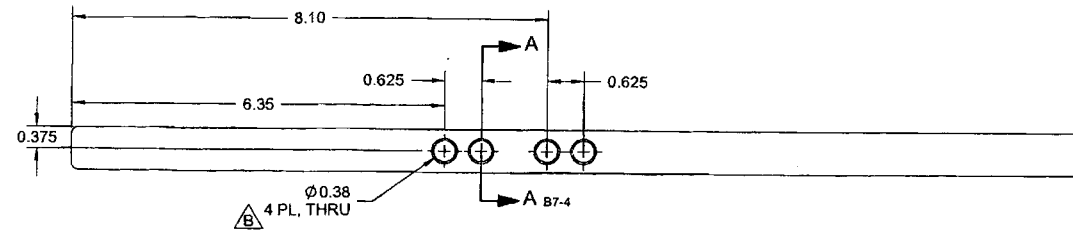


**D4034-1 RIB**

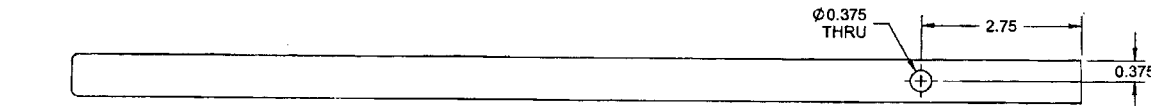
BREAK EDGE  
0.030 X 45°  
TYP



**SECTION A-A D4-4**



**D4034-3 RIB**



**D4034-5 RIB**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs  
-3 & -5: 0.62 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4034</b>	SHEET 4 OF 4
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R 2011-01-10 D

81173

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